Quality Control

Work Order Wednesday, April 1	ID 68469 3, 2011 4:15:55 PM									Page 1
Revision ID: Item Name: Sp	3455-1 9acer 13/2011 Start Qty: 30.00 20/2011 Req'd Qty: 30.00			Cust Item ID Customer:			s s	etup Stai		
Approvals: F	Process Plan:	Date: // //_	B Tooling:	Dat			R	dun Stai	##	
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3455	Rev A									
Hardinge CNC Lathe St	Hardinge CNC LATHE Memo mall HARDHIN ,□FOLIO F		0.00 0.00 S PER FOLIO FA583 & DW V: = 2-DEBURR /	AS REQUIRED			30	Þ		
QC Quality Control	QC2- Inspect parts off r Memo	machine FAI/FAIB	0.00				30	\$		
120 	QC8- Inspect parts - sec	cond check	0.00	7	7		30	Ø		

	•							ζ.						
W/O:	V/O:		W	ORK ORDER CHANGE	S									
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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							1							
		,												
Part No: PAR #: _		PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	Date:						
	R	esolution:	Disposition	on:	QA: N/C	closed:		Date:						
NCR:		V	VORK ORD	ER NON-CONFORMAN	ICE (NC	R)								
DATE	STEP	Description of NC	Corrective Action Section		Verification Approval App									
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector					
									•					
	_													

Work Order ID 68469

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Wednesday, April 13, 2011 4:15:55 PM

Item ID:

Revision ID:

D3455-1

Accept



Setup Start



Item Name:

Spacer

4/13/2011

Start Qty: 30.00 Req'd Qty: 30.00

Cust Item ID:

Customer:

Reference:

Start Date:

Approvals:

Process Plan:

Date: _____

Tooling:

Date:

Tool#

Plan

Code

Start

Run

Stop



Required Date: 4/20/2011

QC:

Date:

SPC (Y/N):

Tool ID

Date:

Stop

Reject

Number

Insp.

Stamp

Sequence ID/

Work Center ID

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo

Deburr if necessary.

Set Up/ Run Hours

0.00

185/17

Accept

Qty

Reject

Qty

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

150

Packaging

Identify as per dwg & Stock Location:

0.00

0.00

Memo

Memo

Packaging

	-											
W/O:			W	ORK ORDER CHANG	SES					1.3		
DATE	STEP	PRC	CEDURE CH	ANGE	B	,	Date	Qty	Approval Chief Eng / Prod Mgr	e:		
-									r rod mgr			
		<i>*</i>										
Part No: PAR #:			Fault Cate	egory:	_ NCR: \	'es N	lo DQ	A:	_ Date: _			
	R	esolution:	Disposition	on:	QA: N/C Closed:							
NCR:		1	WORK ORE	DER NON-CONFORM	ANCE (N	ICR)	_					
DATE	CTED	Description of NC			tion B		Verification Approval Approval Section C Chief Eng OC Inspector					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn &)ate	Sect	tion C	Chief Eng			
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Work Order ID 68469

Page 3

Wednesday, April 13, 2011 4:15:55 PM

Item ID:

D3455-1

Accept



Setup Start



Revision ID:

Start Date:

Item Name:

Spacer

4/13/2011

Start Qty: 30.00 Req'd Qty: 30.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Operation

Description

Date:

Tooling:

Date:

Start

Stop



Required Date: 4/20/2011

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/

Work Center ID

160

Memo

QC21- Final Inspection - Work Order Release

0.00

Run Hours

0.00

Set Up/

Tool ID

Tool # Plan Code

Reject Accept Qty

Qty

Run

Reject Number

Insp. Stamp

Quality Control

W/O:			V	ORK ORDER CHANG	ES							
DATE	STEP	PROC	EDURE CH	ANGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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		-										
Part No:		PAR #:	_ Fault Ca	tegory:	_ NCR: Y	es No	DQ.	A:	Date:			
					QA: N/C Closed:							
NCR:		W	ORK OR	DER NON-CONFORMA	ANCE (N	CR)	••••••					
DATE	STED	Description of NC Corrective Action Section B				Verific	ation	Approval	Approval			
DATE	ATE STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Secti	on C	Chief Eng	QC Inspector			
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		,										
									4 4 8 9 9 9 9 9 9 9 9 9			

Picklist Print

Wednesday, April 13, 2011 4:16:01 PM

Work Order ID: 68469

Parent Item:

D3455-1

Parent Item Name:

Spacer



Start Date: 4/13/2011

Required Date: 4/20/2011

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP REV. A

05.11.17

NEW ISSUE

EC

Component Item	ID/
Item Name	

Replacement Mfg/ Item ID

Purch

Bin **Primary** Item Location

Last Location Route Seq ID

Unit of Measure

Qty on Hand

Qty per Kit

Oty Issued Date Issued

Status

Page 1

MDELRINR1.000

Purchased

No

100

f

4.7680

Loc Code

0.022

0.694737

Total

Otv

n18/17

Delrin Round Bar 1"

Location

MAT055

Loc Qty

4.768 4.768

114586

MININGER Round Ban.

ANDERS DAY

INIS DAY

INI

W/O:			W	ORK ORDER CHA	NGES					Ε,		
DATE	STEP	PRO	OCEDURE CHA	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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<u> </u>												
	,											
		•										
Part No:PAR #:		PAR #:	Fault Cate	egory:	NCF	R: Yes N	lo DQ .	A:	Date:			
	Re	solution:	Disposition	on:	QA: N/C Closed: Date:							
NCR:		· · · · · · · · · · · · · · · · · · ·	WORK ORD	ER NON-CONFO	RMANCE	(NCR)						
547	0750	Description of NC		Corrective Action	Section B		Verifi	cation	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Descript Chief Eng	ion	Sign & Date		ion C	Chief Eng	QC Inspector		
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DART AEROSPACE LTD	Work Order:	48469
Description: Spacer	Part Number:	D3455-1
Inspection Dwg: D3455 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	FIRS	ST ARTICLE II		_			
		X First Arti	cle	Prot	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Con	nments
Ø0.453	+0.005/-0.000	01754			2/-	>	
Ø1.00 t/	+9.010/-0.001	1.001	-/				
0.065	+/-0.010	«O65°					

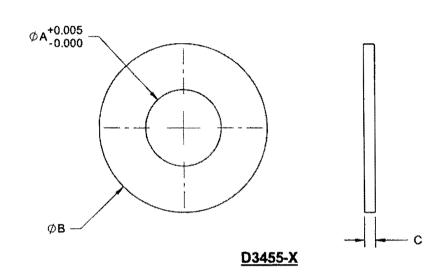
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Measured by:	77	Audited by:	 		Prototype	Approval:	N/A
Date:	11/5/17	Date:	2:11	. 17		Date:	N/A
Rev Date	Change					Revised by	
A 06.07.11	New Issue					KJ/JLM of	3

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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
CHECKED	APPROVED W	DRAWING NO. D3455	REV. A SHEET 1 OF 1			
DATE C	5.09.02	TMLE SPACER	SCALE 2:1			
Α	05.09.02	NEW ISSUE				





1) SPECIFICATION: D3455-X SPACER

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)
-1	0.453	1.00	0.065
-3	0.386	1.00	0.050

CQUIOS117 @10: 68469

NOTES:

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-R)
 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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